

Work Order ID 104442

104442

Page 1

July-11-13 10:41:19 AM

Item ID: D4027-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hose Clamp Assembly

Start Date: 7/11/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/18/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4027

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Drill hole and assemble as per dwg notes

4 4 13-08-28

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

13-8-29

4

120

Identify as per dwg & Stock Location: 87242B

0.00

120

Packaging

Memo

0.00

Packaging

4x 50 13-8-29

Work Order ID 104442

104442

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July-11-13 10:41:19 AM

Item ID: D4027-041 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Hose Clamp Assembly
Start Date: 7/11/13 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 7/18/13 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

13/9/38
RB-08-29

Picklist Print

July-11-13 10:41:18 AM

Page 1

Work Order ID: 104442
Parent Item: D4027-041
Parent Item Name: Hose Clamp Assembly

Start Date: 7/11/13 Required Date: 7/18/13
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP rev A 10.02.01 new issue Prelim - EC verified by:JLM IPP Rev:B 10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4027-1 Hose Clamp		Manufactured	No			100	Each	6.0000	1	4		FF 13-08-28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST449	105027	6				4			
				83654		6							
D4027-8 Rubber Cushion		Manufactured	No			100	Each	8.0000	1	4		FF 13-08-28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA	83970	8				4			
				8947		8				4			
AN743-13 Bracket		Purchased	No			100	Each	68.0000	1	4		FF 13-08-28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST347		68							
				121825		1							
				123352		10				4			
				M126010		20							
				M126119		12							
				M126249		25							
MS24693-S28 Screw		Purchased	No			100	Each	107.0000	1	4		FF 13-08-28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST301		10							
				4824		10							
				ST302		97							
				11334		56				4			
				8170		41							

Picklist Print

July-11-13 10:41:19 AM

Page 2

Work Order ID: 104442
 Parent Item: D4027-041
 Parent Item Name: Hose Clamp Assembly

Start Date: 7/11/13

Required Date: 7/18/13

Start Qty: 4.00

Required Qty: 4.00

NAS1149DN632J
 Washer

Purchased

No

100

Each

655.0000

1

4

FF 13-08-28

Location

Loc Qty

Loc Code

ST293 126257

605

4

123900

5

M126084

600

ST510a

50

125646

50

MS21042L09

Nut

Purchased

No

100

Each

0.0000

1

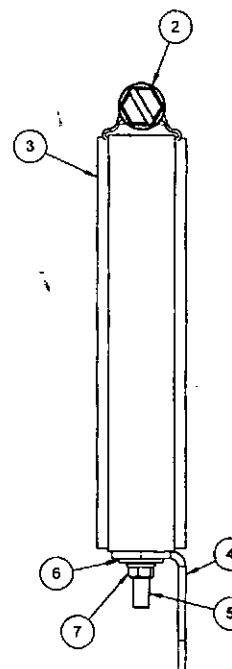
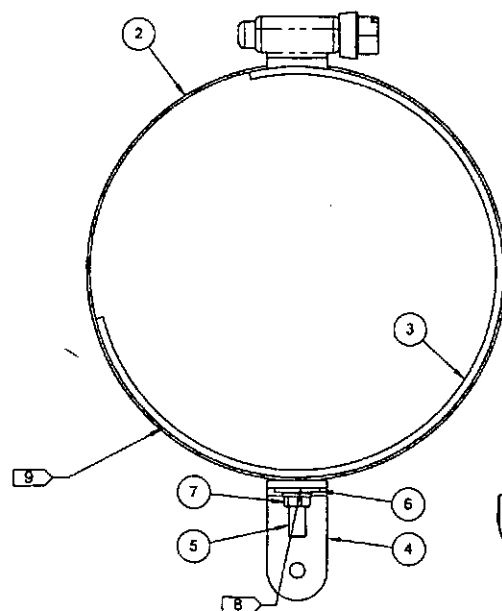
4

FF 13-08-28

06
 5228
 80
 13.08.26

125303

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-041	VENT CLAMP ASSEMBLY	JCA-M47-2-20
2	1	D4027-1	HOSE CLAMP	
3	1	D4027-5	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT ANGLE	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



D4027-041 VENT CLAMP ASSEMBLY

NOTES:

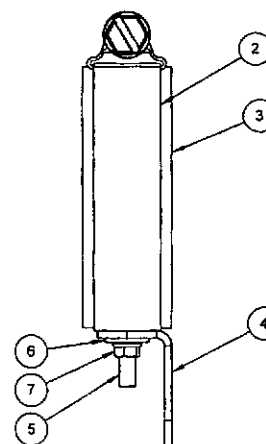
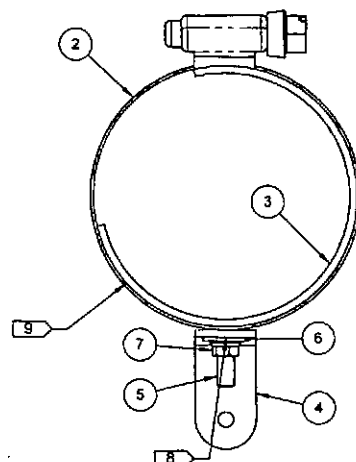
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-5 RUBBER CUSHION TO D4027-1 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

RELEASED
2010-05-05

A		NEW ISSUE		10.04.16	
REV.		DESCRIPTION	BY	DATE	
DESIGN					
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE		10.04.16			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4027	REV. A
TITLE CLAMP	SCALE NTS
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-043	VENT CLAMP ASSEMBLY	JCA-M47-2-35
2	1	D4027-3	HOSE CLAMP	
3	1	D4027-7	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT CLAMP	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



D4027-043 VENT CLAMP ASSEMBLY

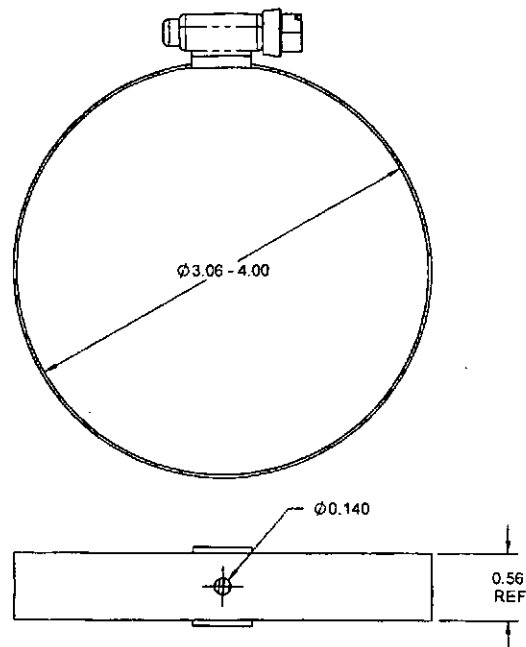
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2010-05-05
NHS

NOTES:

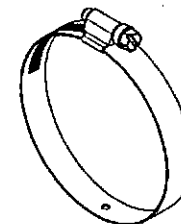
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-7 RUBBER CUSHION TO D4027-3 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-1	REF JCA-M47-2-20



D4027-1 HOSE CLAMP



NOTES:

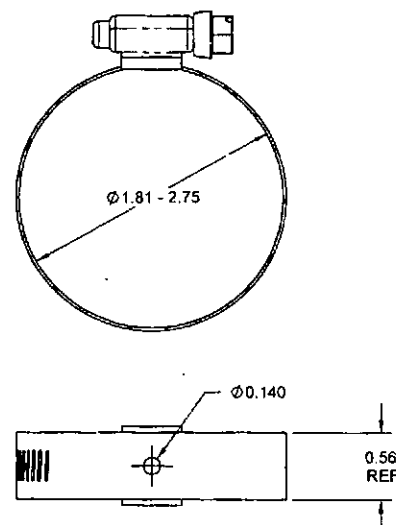
- 1) MATERIAL: MADE FROM QS200M56S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

RELEASED
2010-05-15
JMB

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-3	REF JCA-M47-2-35



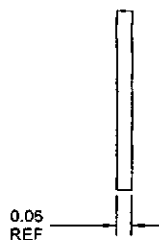
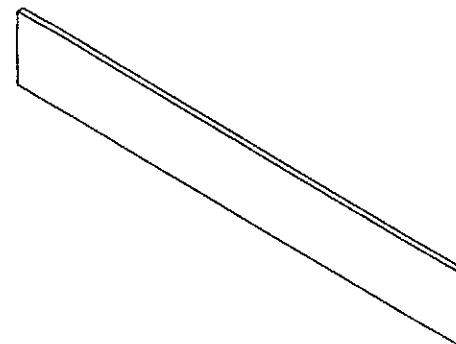
D4027-3 HOSE CLAMP

RELEASED
2010-05-05
WJ

- NOTES:**
- 1) MATERIAL: MADE FROM QS200M36S
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-3" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.05 lbs
 - 8) DRILL Ø0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-5	REF JCA-M47-2-20
D4027-7	REF JCA-M47-2-35



DART PART NUMBER	LENGTH "L"
D4027-5	5.30
D4027-7	8.25

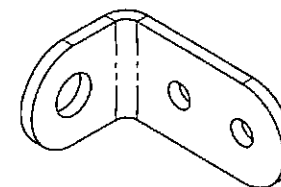
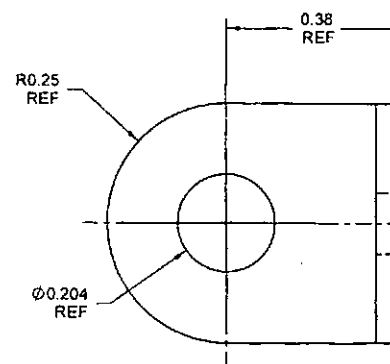
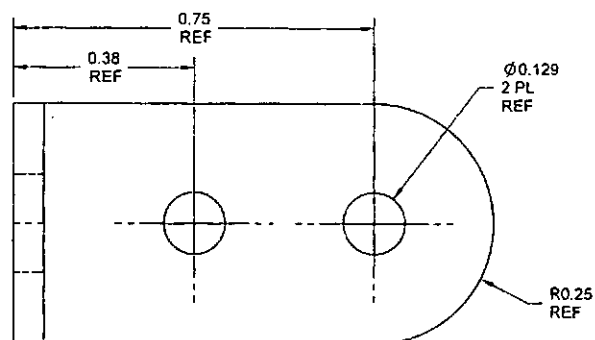
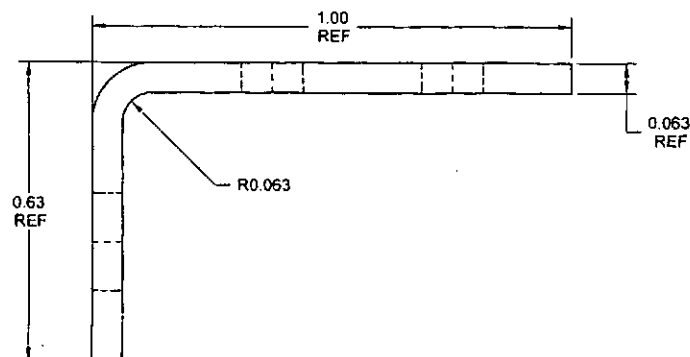
D4027-X RUBBER CUSHION

RELEASED
2010-05-05
MJP

- NOTES:
- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK
REF DART SPEC M-NEO-60-S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-9	REF JCA-M47-2-20/-35



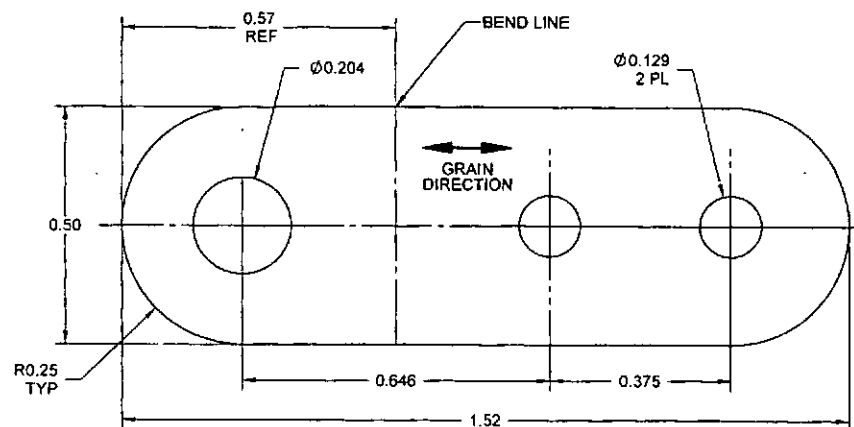
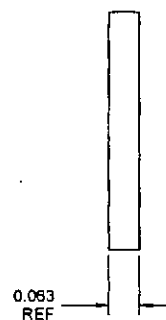
D4027-9 BRACKET, SUPPORT ANGLE

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: MADE FROM D4027-9F OR EQUIVALENT TO AN743-C13
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

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D4027-9F FLAT PATTERN

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 THICK
PER AMS5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 LBS

DESIGN		DART AEROSPACE LTD	
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